



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.1814

Job Sheet 168028



Part No: 647.1814

Job Qty: 10 ea

Part Name: Gusset LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/9/17

Job Tracking No:

Due Date: 11/24/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV A SHEET 5 IPP REV:A 12.10.03 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	11/23/17	11/23/17	0.00	0.00	Start up container		SC
110	Waterjet	10 pcs	11/23/17	11/23/17	0.00	1.63	Waterjet1		SC
120	QC	10 pcs	11/23/17	11/23/17	0.00	0.00	QC2		SC DAS
130	QC	10 pcs	11/23/17	11/23/17	0.00	0.00	QC8		38
140	Brake NC	10 pcs	11/23/17	11/23/17	0.00	1.16	Brake NC 1		DAS 9-89
150	QC	10 pcs	11/23/17	11/23/17	0.00	0.00	QC5		38
160	Outsource	10 pcs	11/23/17	11/23/17	0.00	0.00	Outsource4		9-89
170	Packaging	10 pcs	11/23/17	11/23/17	0.00	0.00	Packaging2		18.07.05
180	QC	10 pcs	11/23/17	11/23/17	0.00	0.00	QC5		38
190	SprayPaint	10 pcs	11/24/17	11/24/17	0.00	1.11	Spray Paint		9-89
200	QC	10 pcs	11/24/17	11/24/17	0.00	0.00	QC1		DAS
210	Packaging	10 pcs	11/24/17	11/24/17	0.00	0.00	Packaging3		6
220	QC21-SA	10 Ea	11/24/17	11/24/17	0.00	0.00	QC21		9-89

Part Op 110 - 1-Cut as per Dwg Dwg Rev: A Prog Rev: A 2-Deburr if necessary

Descriptions: 160 - ISSUE P/O: HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)

190 - PRIME IAW MIL-P-23377J TYPE1 CLASS N AS PER DWG. (SEE NOTE 2) CARDINAL 4860-50 PRIMER

BATCH:

210 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M2024T3S.040	1	241	0	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE
S012454



Gusset LH

PART NO: 647.1814
Revision:
Operation: Start up Operation
Change No:

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Mfg Date: 11/22/17

Job No: 168028

APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03686				SHEET 1 OF 2	
	DWG NO. 647.1800	REV: N/C	PREPARED BY B. PETERS	DATE: 11/12/12	EFFECT ON DWG ☒ INC. ☐ UNINC.	
	DWG TITLE: SHEETMETAL					
	APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: CURRENT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: REVISED RADIUS ON SHEETMETAL BEND.				ECR: D-12-020	

NOTES:

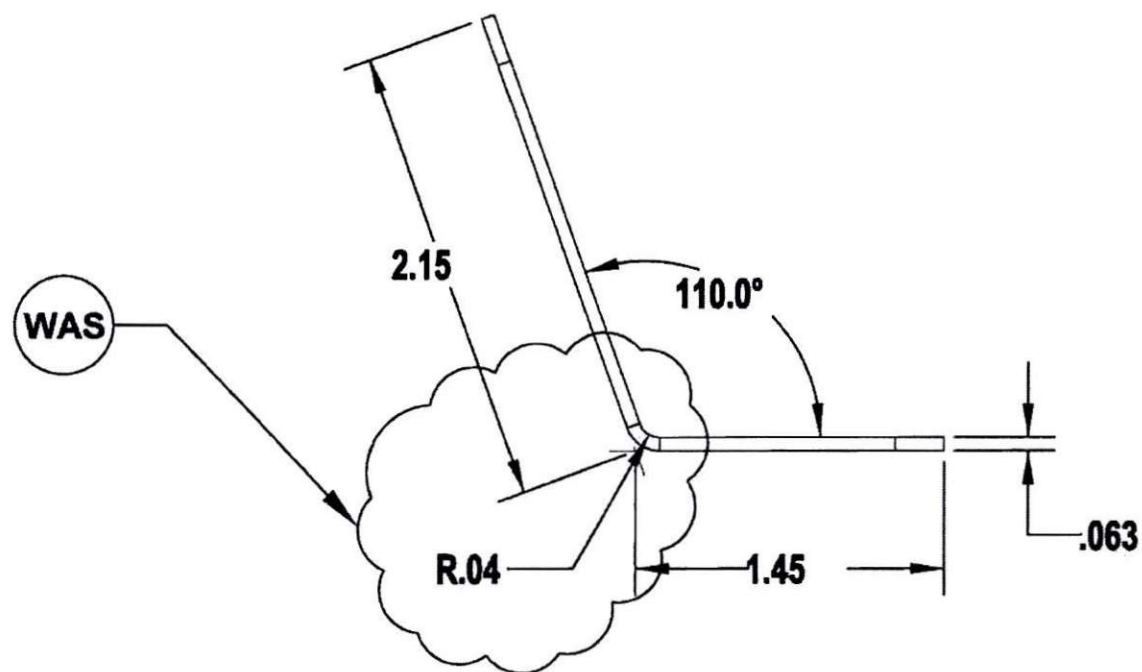
- 1 MATERIAL: ALUMINUM 2024-T3 PER AMS-QQ-A-250/4
- 1 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
CARDINAL 4860-50 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N
3. DEBURR AND BREAK ALL SHARP EDGES
4. IDENTIFY IAW MPP-120

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER *DAS*
NO. 168 028 30 989

NOV 10 2017

SHEET 1, ZONE A1 WAS:

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				☐ RFMS ☐ MDL ☐ INSTALL INSTRU ☐ ICA ☐ BOM	CHANGE CATEGORY ☐ MAJOR ☒ MINOR	DER REVIEW REQUIRED ☐ YES ☒ NO



SHEET 4, ZONE D5 WAS:

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE REVISION: P92		N/C
N/C	INITIAL RELEASE	06/01/89	P. BRAVO
A	INCORPORATED ECH 0388	11/02/12	P. BRAVO

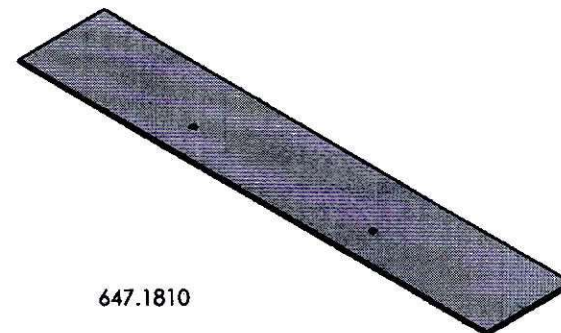
NOTES:

△ PRIMARY MATERIAL: 2024-T3 ALUMINUM PER AMS-QQ-A-250/4
ALTERNATE MATERIAL: 6061-T6/T62 ALUMINUM PER AMS-QQ-A-250/11

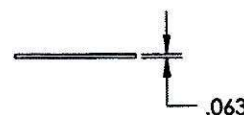
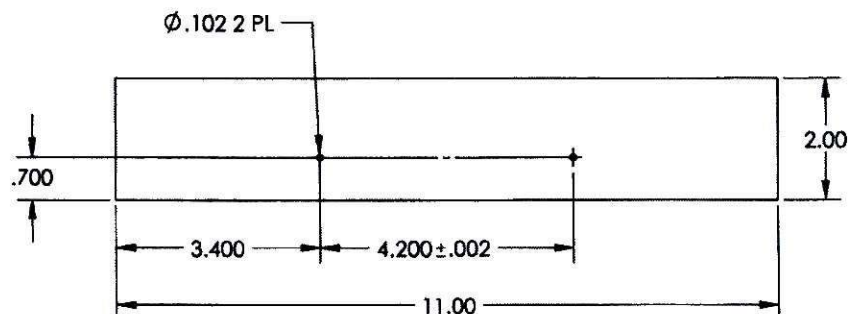
△ FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III,
CLASS 2, COLOR BLACK;
CARDINAL 4860-S0 PRETREATMENT PRIMER
PRIME IAW MIL-P-23377J TYPE I CLASS N

3. DEBURR AND BREAK ALL SHARP EDGES

4. IDENTIFY IAW MPP-120



647.1810

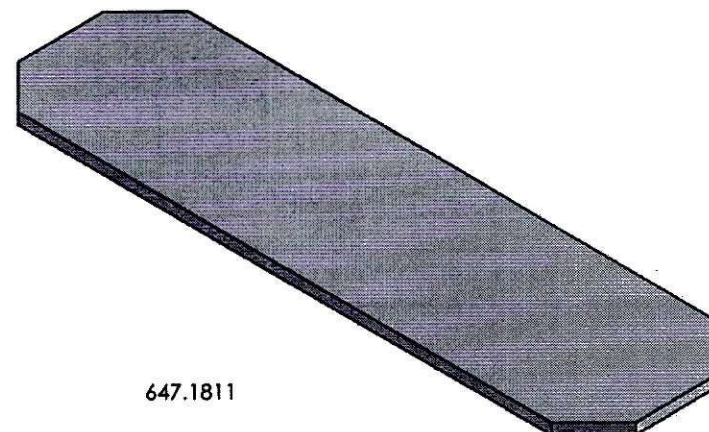
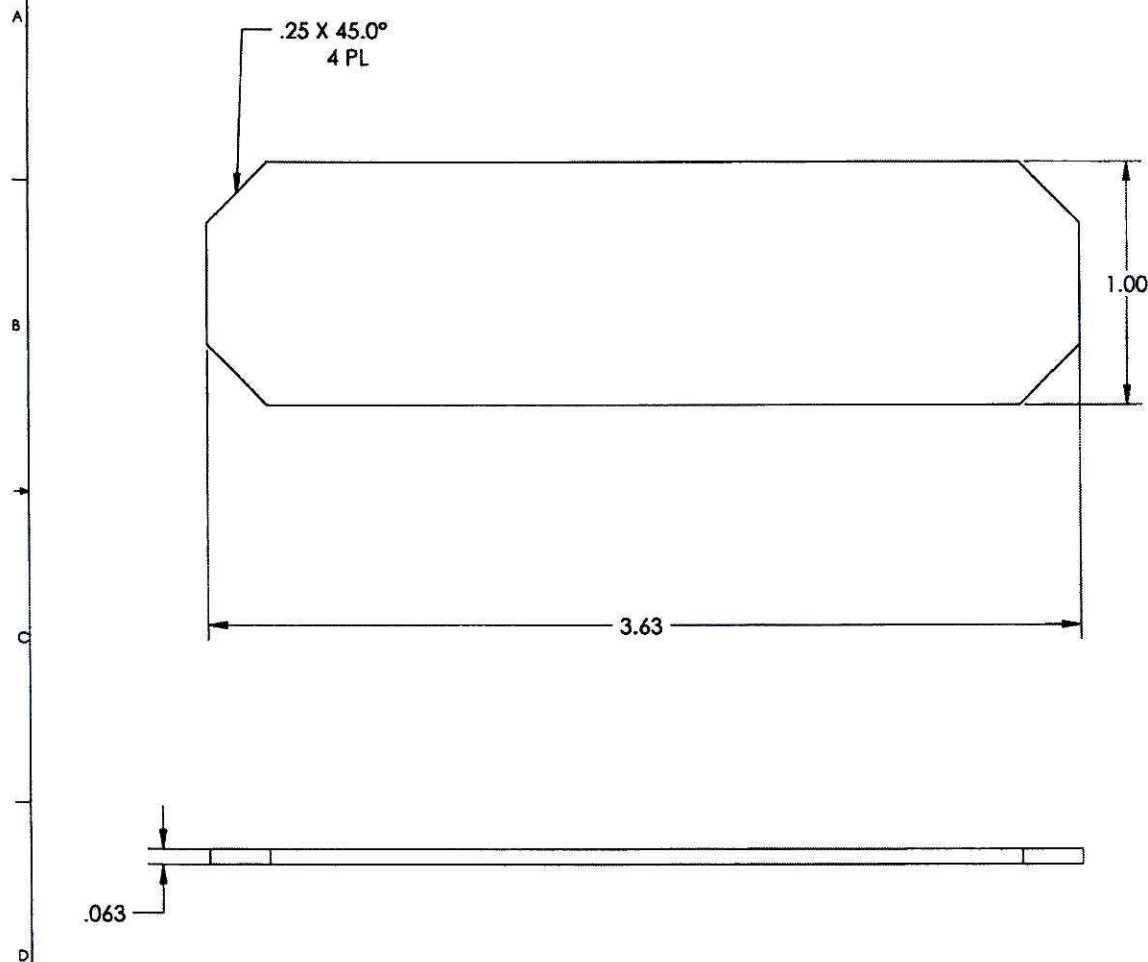


.063

647.1818	NOSE DOOR SPACER	△	△
647.1817	SUPPORT, RH	△	△
647.1816	SUPPORT, LH	△	△
647.1815	GUSSET, RH	△	△
647.1814	GUSSET, LH	△	△
647.1813	ANGLE	△	△
647.1812	SHIM	△	△
647.1811	SPACER	△	△
647.1810	NOSE DOOR DOUBLER	△	△

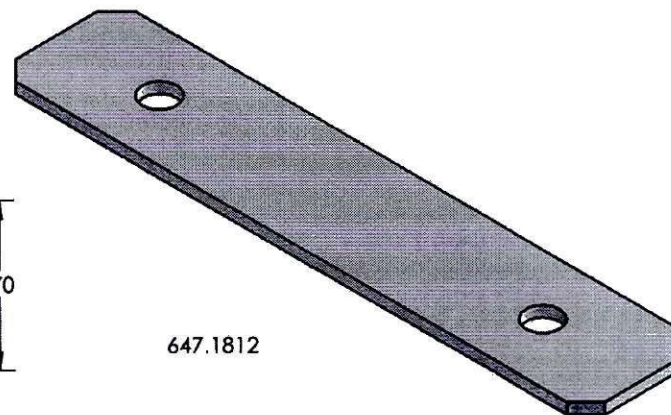
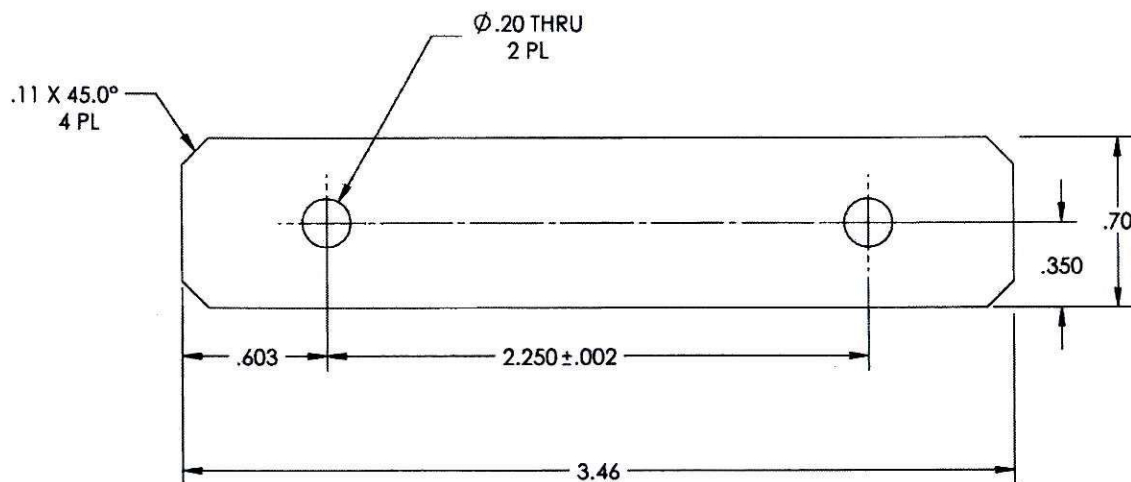
QTY	FIND #	PART #	DESCRIPTION	MATL	SPEC.
PARTS LIST					
APICAL INDUSTRIES					
2608 TEMPLE HEIGHTS DR.					
OCEANSIDE, CA. 92056-3512 (760)724-5300					
SHEETMETAL					
UNLESS OTHERWISE SPECIFIED					
DIMENSIONS ARE IN INCHES					
TOLERANCES ARE:					
2 PLACE DECIMALS ±.01					
3 PLACE DECIMALS ±.005					
ANGLES ±.5°					
SCALE: NONE					
SHEET 1 OF 7					

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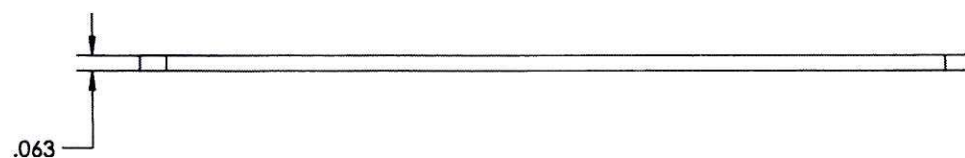


ORIGINAL DATE 06-01-99		APICAL INDUSTRIES	
DRAWN BY J. CLAPTON	CHECKED P. BRAVO	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAVO		SHEETMETAL	
CONTRACT NO.		REV	A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS .031 2 PLACE DECIMALS .005 ANGLES ± .5°		SCALE: NONE	SHEET 2 OF 7

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647.1812



ORIGINAL DATE BAC-DA-175 05-01-08		APICAL INDUSTRIES	
DRAWN BY J. GARDNER	CHECKED P. BRAYO	2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAYO		SHEETMETAL	
CONTRACT NO.		SIZE B	REV A
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		CAGE CODE 07M26	DWG. NO. 647.1800
		SCALE: NONE	SHEET 3 OF 7

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.23 X 45.0°
PL

UP 70.0° R .13

(1.42) (2.11)
3.53

FLAT PATTERN

3.63

2.15

110.0°

R.125

1.45

.063

647.1813

ORIGINAL DATE
UNO-04-175 06/01/09
DRAWN BY
J. GAYNOR
CHECKER
P. BRAVO
DRAWING APPROVAL
P. BRAVO
DATE
CONTRACT NO.

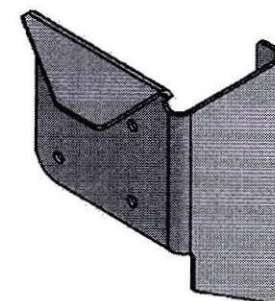
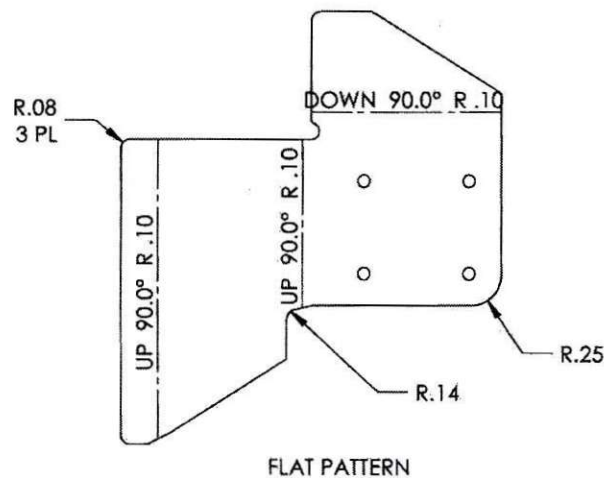
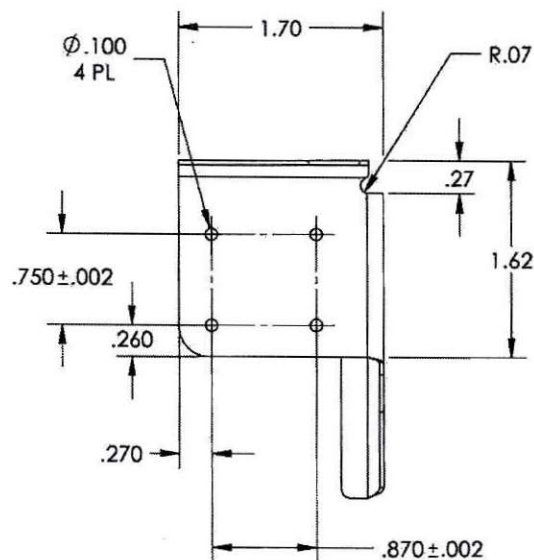
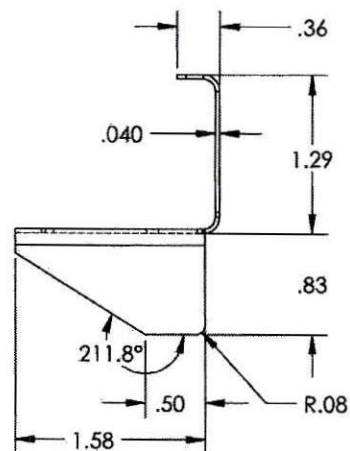
UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
TOLERANCES ARE:
2 PLACE DECIMALS ±.01
3 PLACE DECIMALS ±.005
ANGLES ±.5°

APICAL INDUSTRIES
2608 TEMPLE HEIGHTS DR.
OCEANSIDE, CA. 92056-3512 (760)724-5300

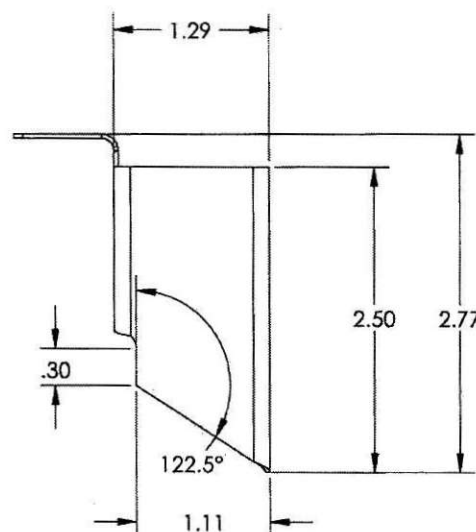
SHEETMETAL

SIZE	CAGE CODE	DWG. NO.	REV.
B	07M26	647.1800	A
SCALE: NONE			SHEET 4 OF 7

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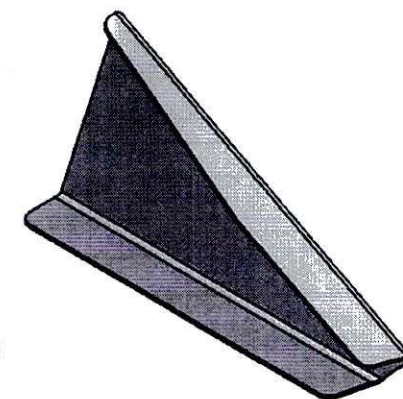
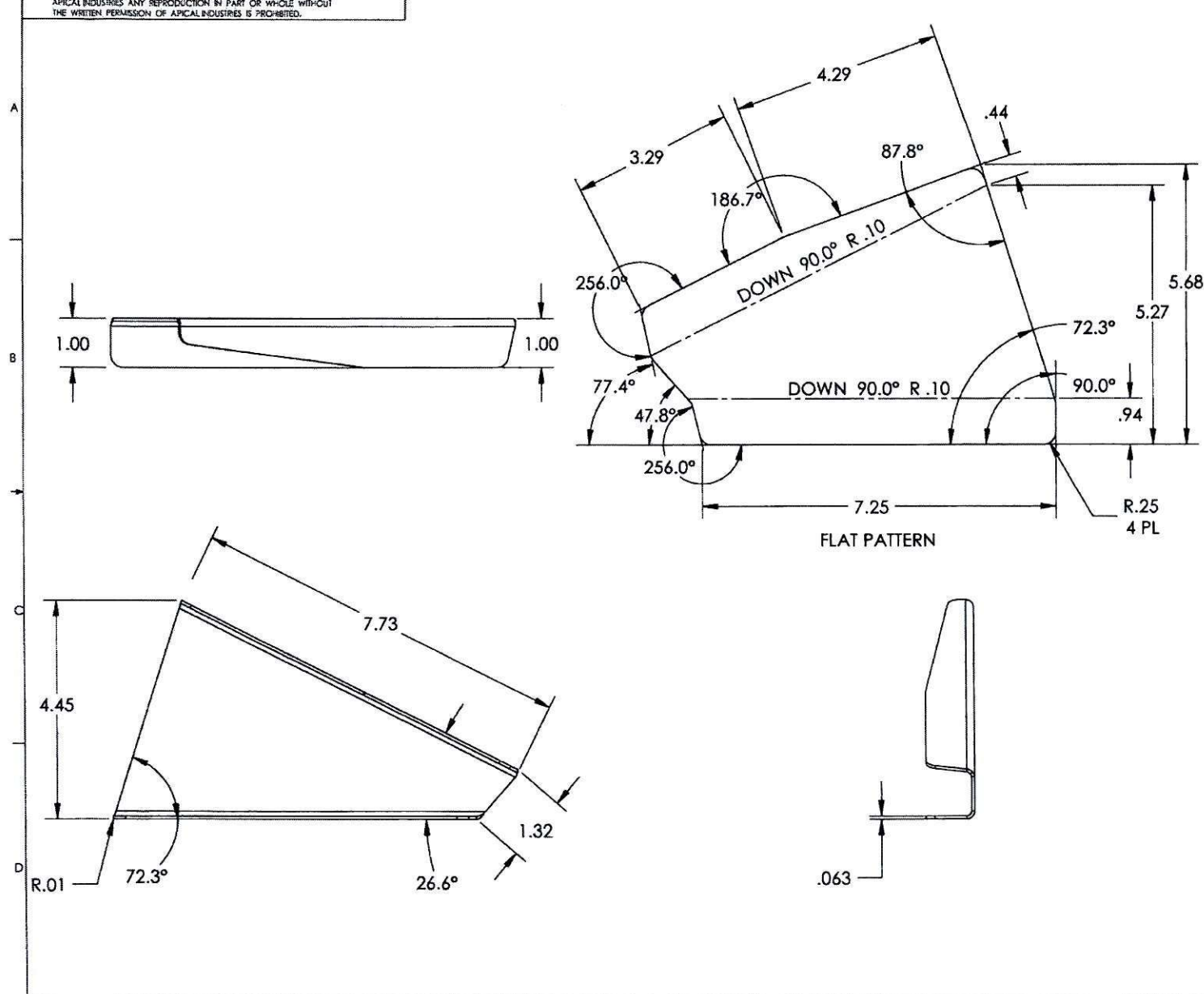


647.1814 SHOWN
647.1815 OPPOSITE



ORIGINAL DATE (MM/DD/YY) 06-01-01 DRAWN BY: J. GARDNER J. GARDNER P. BRAVO DRAWING APPROVAL P. BRAVO 06-01-01 CONTRACT NO.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
(UNLESS OTHERWISE SPECIFIED) DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SHEET B	DWG. NO. 647.1800
SCALE: NONE		REV A	SHEET 5 OF 7

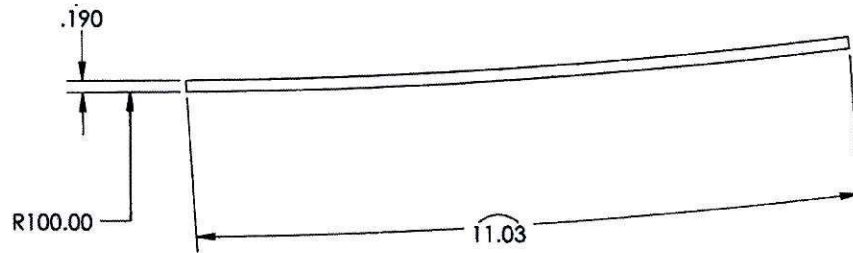
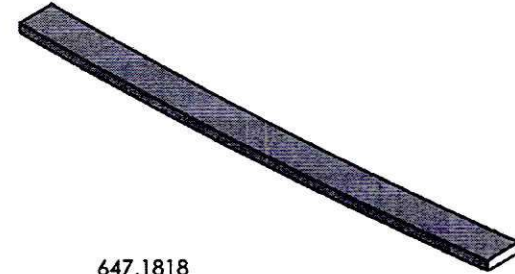
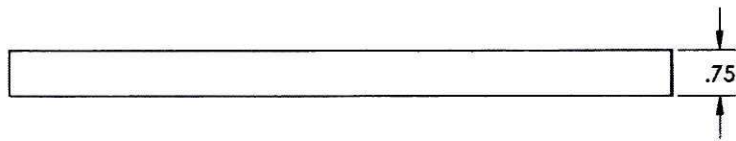
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647.1816 SHOWN
647.1817 OPPOSITE

APICAL INDUSTRIES	
2608 TEMPLE HEIGHTS DR.	
OCEANSIDE, CA. 92056-3512 (760)724-5300	
SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°	FORMAL DATE 1/20/04-19 DESIGNER CS-010P DRAWN BY J. GARDNER CHECKED BY P. BRAVO DESIGNED APPROVAL P. BRAVO INTEGRITY INTEGRITY CONTRACT NO.
SIZE 8 CAGE CODE 07M26 DWG. NO. 647.1800 REV. A	SCALE NONE SHEET 6 OF 7

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ORIGINAL DATE 10/04/98 08:01:09		APICAL INDUSTRIES	
DRAWN BY J. GARDNER		2608 TEMPLE HEIGHTS DR.	
CHECKED BY P. BRAYO		OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWING APPROVAL P. BRAYO		SHEETMETAL	
CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ±.2°		SHEET B	REV A
CAGE CODE 07M26		DWG. NO. 647.1800	
SCALE: NONE		SHEET 7 OF 7	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040356**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalonde, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040356
PO Date: 6/28/18
Due Date: 7/13/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	178641	SWA10A-700	Wire Clamp -Issue P/O to ATG: _____ -HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 3 CLASS 2 -Certificate of Conformity is required	Firmed	7/13/18	40 pcs	0 pcs	40 pcs	\$8.00/pcs	\$320.00
2	179370	647.7811	Bracket B Issue P/O to ATG : _____ Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A	Firmed	7/13/18	4 pcs	0 pcs	4 pcs	\$16.75/pcs	\$67.00
3	179369	647.7810	Bracket A Issue P/O to ATG : _____ Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A	Firmed	7/13/18	6 pcs	0 pcs	6 pcs	\$16.75/pcs	\$100.50
4	168294	647.1814	Gusset LH ISSUE P/O: _____ HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)	Firmed	7/13/18	4 pcs	0 pcs	4 pcs	\$9.15/pcs	\$36.60
	168028			Firmed	7/13/18	10 pcs	0 pcs	10 pcs	\$9.15/pcs	\$91.50
Sub Total:						14	0	14		\$128.10

DAS
38
9-89

5	173890	RBE350A93-3302-02-5	Extension Handle -Issue P/O to ATG: _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Certificate of Conformity is required	Firmed	7/13/18	12 pcs	0 pcs	12 pcs	\$12.25/pcs	\$147.00
6	168295	647.1815	Gusset RH ISSUE P/O: _____ HARD ANODIZE, COLOR BLACK AS PER DWG.(SEE NOTE 2)	Firmed	7/13/18	4 pcs	0 pcs	4 pcs	\$9.15/pcs	\$36.60

Plex 7/3/18 8:11 AM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T7
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 915492

Date: 04-Jul-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
40 ea	Part: SWA10A-700 Wire Clamp Hard Anodize per MIL-A-8625F, Type III, Class 2, Black, .0005-.0045" (.5 - 4.5mils) Job: 23372 PO: PO040356 Line: 1 Rev: 4		
4 ea	Part: 647.7811 BRACKET B Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 23373 PO: PO040356 Line: 2 Rev: A		
6 ea	Part: 647.7810 Bracket A Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 23374 PO: PO040356 Line: 3 Rev: A		
14 ea	Part: 647.1814 Gusset LH Hard Black Anodize per MIL-A-8625, Type III, Class 2, .0005-.0045" (.5 - 4.5 mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 23375 PO: PO040356 Line: 4 7 Rev: A		
4 ea	Part: 647.1815 Gusset RH Hard Black Anodize per MIL-A-8625, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 23380 PO: PO040356 Line: 6 Rev: A		
Made in Canada.			

DAS
38
9-89



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 915492

Date: 04-Jul-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>4/2/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.		
DAS 38 9-89			
Made in Canada.			